

Date: Tuesday, 1/16/2007 11:28:25 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 30273	
Estimate Number : 10256	
P.O. Number : N/A	Part Number : D22303
This Issue : 1/16/2007 S.O. No. : N/A	Drawing Number : D2230 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 29806	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 1/30/2007 Qty: 300 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est D 00.95.18 Added inspection level 8, and removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
Comment: Qty.: 0.0717 f(s)/Unit Total : 21.5145 f(s) Lug Extrusion D2423 Batch: <u>30062</u> BG 07.01.18 300		
2.0	BAND SAW	BAND SAW
Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <u>30062</u> BG 07.01.18 300		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. <div style="text-align: right;"> <i>Issue P-O 2902</i> <i>machine per drawing D2230 Rev F</i> </div>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <div style="text-align: right;"> <i>Receive & Inspect for transit</i> <i>change 04/02/06 (299)</i> </div>		
5.0	QC3	SECOND CHECK
Comment: SECOND CHECK <i>Inspect level 5</i> <i>As per QSR015</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DP* Date: 07/02/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:28:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30273

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



300

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

SB

07/02/14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



300

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-B / YL

07/02/14

8.0

QC5

INSPECT WORK TO CURRENT STEP



300

Comment: INSPECT WORK TO CURRENT STEP

M 07 02 14

9.0

POWDER COATING

POWDER COATING



300x

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M-B / YL

07/02/14

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



299

Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

CP 04/02/22

299

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S1370

CP 04/02/22 299

CP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



299

Comment: FINAL INSPECTION/W/O RELEASE

07/02/23

Job Completion



U 07/02/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

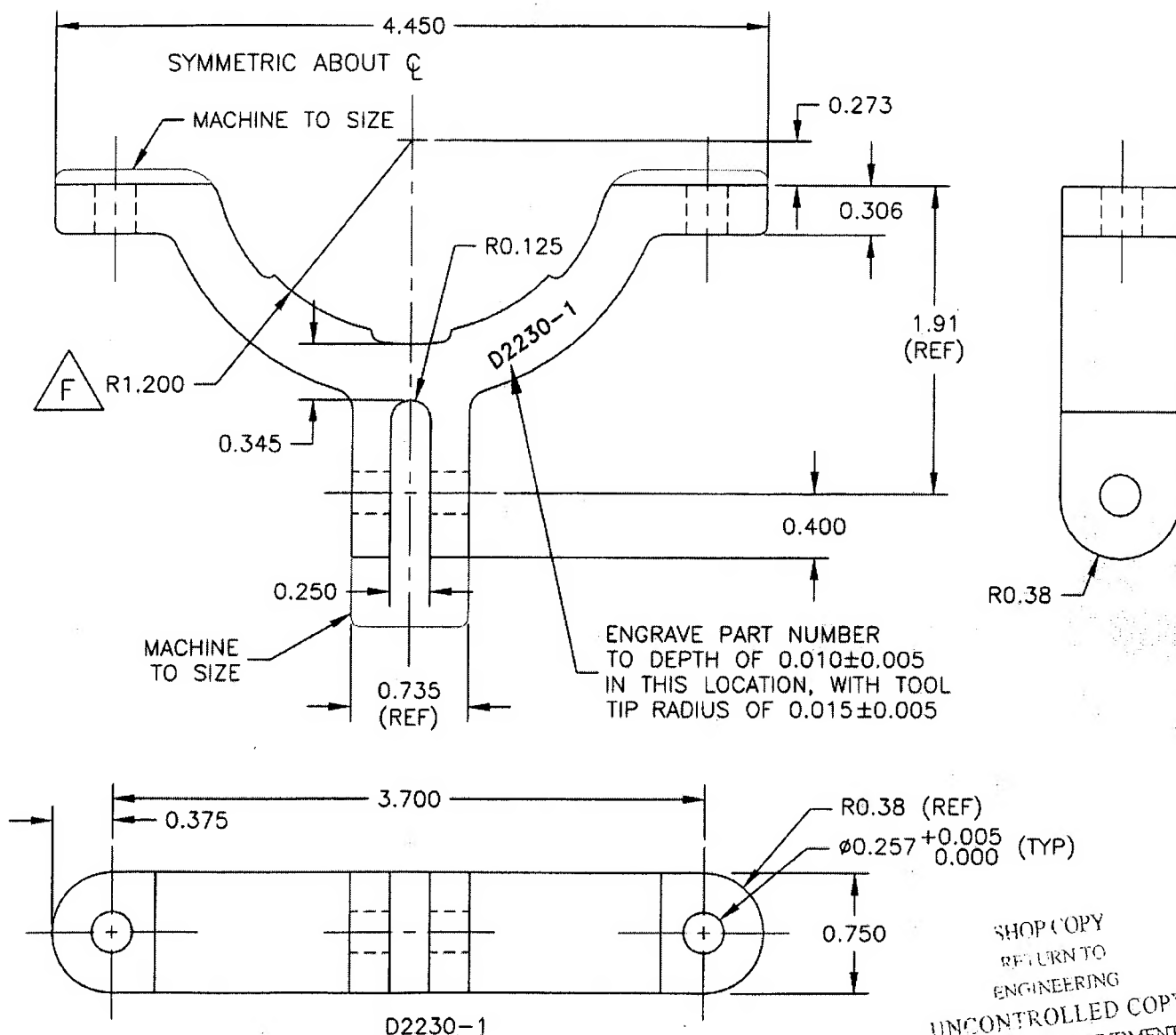
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99-12-21 DS

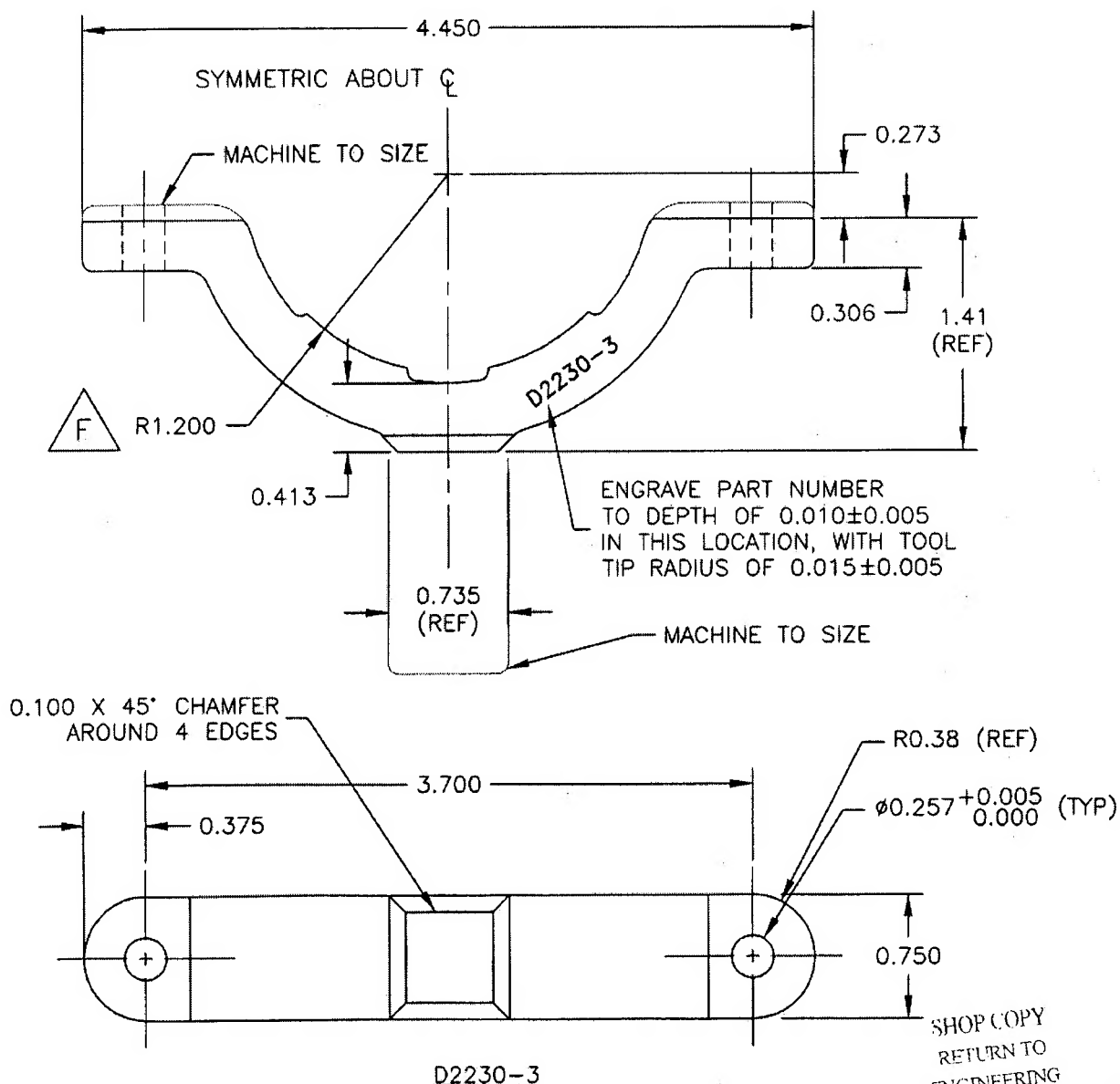
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30273



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
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WORK ORDER
NO. 30273



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

299

D2230-3

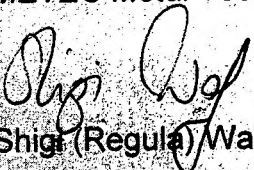
Lug B30273

2902

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, February 6, 2007

